

An improved single-stage method for building the tire includes the steps of forming a cylindrical-shaped carcass with axially extending carcass reinforcing cords, fitting annular bead hoops onto the radially outer surface of the carcass ply at positions axially inward of each of the carcass ply edges, assembling a plurality of breaker plies, including one wide breaker ply, centrally onto and about the radially outer surface of the carcass ply, and fitting onto this cylindrical assembly the remaining components of the tire such as a centrally disposed rubber tread and flanking rubber sidewalls to form a cylindrical green tire assembly. The green tire assembly is shaped into a toroid and then molded in a heated tire mold to form the tread pattern in the tread and vulcanize the whole assembly.